

Date: Thursday, 27/11/2008 2:37:27 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BEARPAW KIT (19"X24")  
 Job Number : 43828  
 Estimate Number : 10972  
 P.O. Number :  
 This Issue : 27/11/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D130700041 D3167-1  
 Drawing Number : D3167 REV A1  
 Project Number : N/A  
 Drawing Revision : A1  
 First Issue : / / Type : MACHINED PARTS  
 Previous Run : 41313 Material :  
 Due Date : 04/12/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : JUD 08-11-27  
 Comment : Est Rev:J 04.02.17 Blank size changed KJ/JLM  
 Est Rev:K 08-01-09 Added Step 2 JLM Verified  
 By:EC  
 Est Rev:L 08-11-08 New Manufacturing Method JLM Verified  
 By:EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D130-700-011CHG001

N/A

2.0 MFG ENGINEERING MFG ENGINEERING



Comment: MFG ENGINEERING

Program Batch Number

JUD 08-11-28

3.0 MUHMWB10 UHMW 1" Black



Comment: Qty.: 7.1610 sf(s)/Unit Total : 14.3220 sf(s)

blank: 20.00" x 24.00" x 1.00" thick (+0.030/-0.000)

Material: Black UHMW 1"

(MUHMWB10)

Batch: ~~108762~~108762 B9-1-12  
LB 8-12-3

①

4.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

Cut Blank as per File D3167-1 BLANK

①

1 part made only for program

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 43828

Part Number: D130700011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA285 and Dwg D3167

3-Deburr

H.A 09/01/13 (1)

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A 09/01/13 (1)

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SS 09/01/20 (1)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

9.0

D2182B

Rubber Cushion



Comment: Qty.: 2.0000 f(s)/Unit Total: 4.0000 f(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
4	D2182B060	Rubber Cushion	

CUT 6.00" LONG

H.A W

10.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
12	D2274	Radius Block	
2	D2432F(ref only)	Bearpaw	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 43828

Part Number: D130700011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	D2519	Clamp
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
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4	D2519	Clamp	
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12.0	D2529	Washer
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

12	D2529	Washer	
----	-------	--------	--

*W/A W*

13.0	D31711	Angle
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
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4	D3171-1	Angle	
---	---------	-------	--

14.0	AN412A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
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4	AN4-12A	Bolt	
---	---------	------	--

15.0	AN415A	Bolt
------	--------	------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

8	AN4-15A	Bolt	
---	---------	------	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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16.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416 Washer

17.0	MS21042L4	Nut
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4)

18.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

19.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D130-700-011

Location: ST 264

20.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



h 09.01.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 43828
<b>Description:</b> Bearpaw		<b>Part Number:</b> D3167-1
<b>Inspection Dwg:</b> D3167	<b>Rev:</b> A1	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.06 x 45°	+0.030/-0.010	0.053 x 45°	✓			
B	5.80	+/-0.030	5.790	✓			
C	0.25 x 45°	+/-0.030	0.25 x 45°	✓			
D	R0.25	+/-0.030	R0.25	✓			
E	0.200	+/-0.030	0.195	✓			
F	0.250	+/-0.010	0.255	✓			
G	0.625	+/-0.030	0.627	✓			
H	0.375	+/-0.010	0.385	✓			
I	0.950	+0.030/-0.010	0.945	✓			
J	3.21	+/-0.030	3.21	✓			
K	19.00	+/-0.030	19.00	✓			
L	Ø0.260	+0.005/-0.000	Ø0.260	✓			
M	Ø0.93	+/-0.030	Ø0.925	✓			
N	0.30	+0.030/-0.000	0.310	✓			
O	0.375	+/-0.030	0.375	✓			
P	7.23	+/-0.030	7.230	✓			
Q	4.54	+/-0.010	4.540	✓			
R	2.00	+/-0.030	2.000	✓			
S	12.000	+/-0.010	12.000	✓			
T	6.000	+/-0.010	6.000	✓			
U	23.75	+/-0.030	23.75	✓			

<b>Measured by:</b> GA	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/01/13	<b>Date:</b> 09/01/20	<b>Date:</b>	N/A

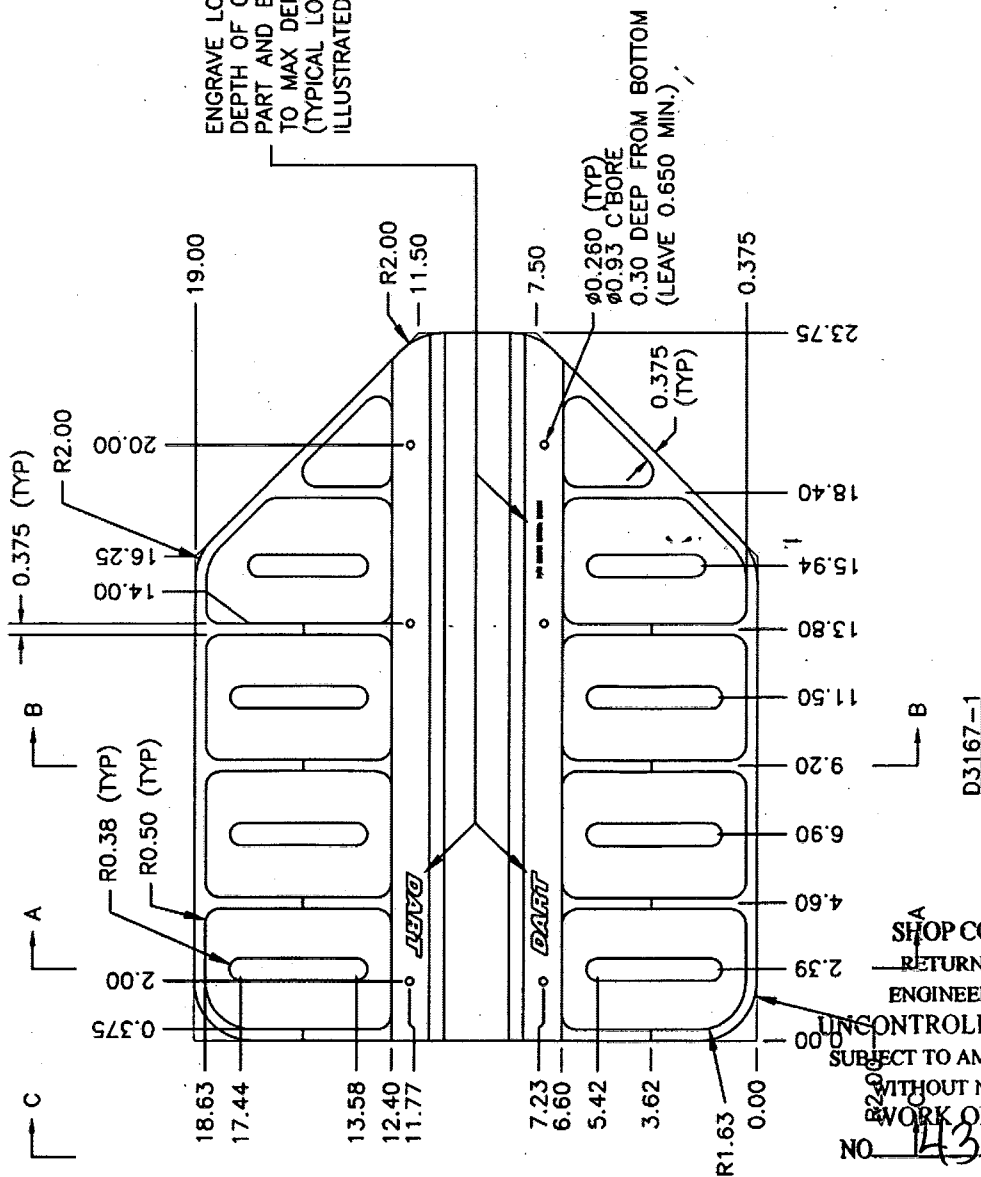
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D130-700-011	KJ/RF [Signature]	[Signature]



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3167	REV. A SHEET 1 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:6
A	02.10.08	NEW ISSUE	
A1	02.12.17	5.80 WAS 5.50 <i>[Signature]</i>	

RELEASED  
02.10.25

ENGRAVE LOGO TO MAX  
DEPTH OF 0.012. ENGRAVE  
PART AND BATCH NUMBERS  
TO MAX DEPTH OF 0.010.  
(TYPICAL LOCATION AS  
ILLUSTRATED)



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SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 143828

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689

1.00 THICK (MACHINE TO 0.950)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

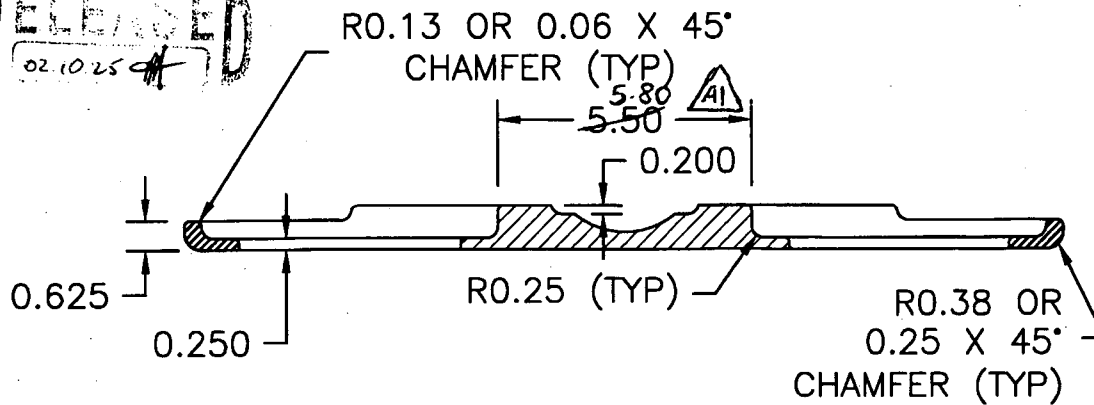
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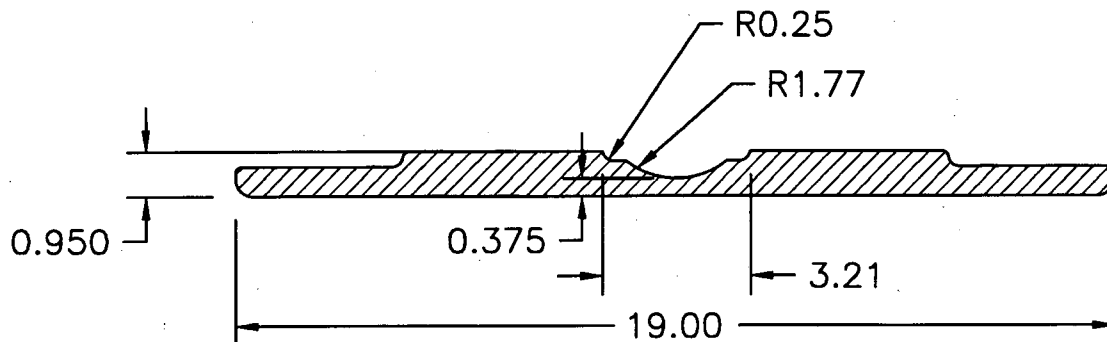


DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3167	REV. A SHEET 2 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:4

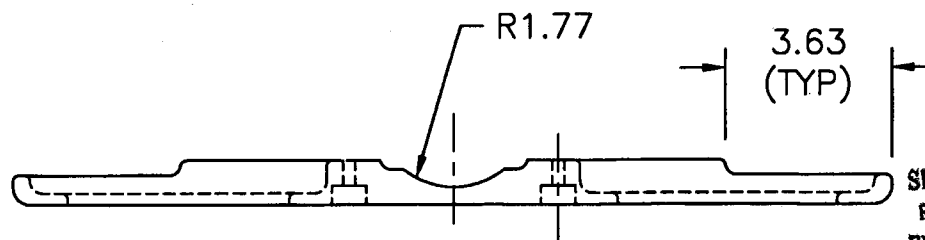
RELEASED  
02.10.25



SECTION A-A



SECTION B-B



SECTION C-C

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NO. 43828

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